Work Order July-19-12 11:09:1			*875	04 *						Page	: 1
Item ID: D4	020-3		Accept	*N900	040	100)* s	etup Star	* * N	S1*	
	esh (350 Basket Short, Base)	1						Stop	*N	S2*	
Start Date: 7/1	0/12 Start Qty: 2.00	*2/*	$\langle 1 \rangle$	Cust Item I	D:					,	
Required Date: 8/0	03/12 Req'd Qty: 2.00	*2* (1×CO	Customer:							
Reference:											
Approvals: P	rocess Plan: MLJ	Date: 12/07/20	Tooling:	Da	ıte:		R	un Star	17	R1*	ı
Q	C:	_ Date:	SPC (Y/N):	Da	ite:			Stop	' *N	R2*	
Sequence ID/ Work Center ID	Operation Description	x c	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
Draw Nbr	Revision Nbr										
D4020	A										
100			0.00								
100	FLOW WATER JET						/x				
Shear	Memo		0.00		1/2.	12 -	7.1				
Shear	I-Cut mesh necessary)	at 56.00" (when mesh is on	D4017-041 trim mesh to	finish size if	/- / 61.	19.0	<i>? *</i> y				
120	QC6- Inspect dimension	s to drawing	0.00		,	1 8			\sim		
120					-0	4	12.1	2.24	-(/x)		
QC	Memo		0.00								
Quality Control		,									
130	Identify as per dwg & Si	tock Location: Who	7 0.00		,						
130 Packaging	Memo		0.00	12.12.21	*		1x				
	MEHIO										

Packaging

NCR:	Yes	/	No
IVCIV.	103	,	110

DQA: Date:

NCR: Y	es / No	:			WORK ORDER NON-	CONFOR	IVIANCE / UP	DATE	QA Closed:	Date	:
Work Orde	r.				DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part N					Rework Scrap]	Skid-tube Machining	Crosstube Small Fab	4	Water Jet d. Eng. Coor.	Engineering Quality Other
NCR N	0		<u> </u>		Use-as-is Work Order Update	Ine	moforming Large Fab	Finishing Composite	, Rec/Stor	re/Packaging Supplier	J Other
Root				Descri	ption of work order update	Initial	Ac	ction	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief En	g Desc	cription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup										[
Other											
Process	_									į	
Supplier	4										
Training	_										
Unapproved			Ll			AULT CAT	EGORY			<u> </u>	
Landin	ng Gear				r General	AULI CAI	LGONT				
	Bending				Bend	Grain		Г	Ovalized	Γ	Pressure/Forced
	Centre No	nt Conce	ntric to (_{2/5}	BOM/Route	Hardy		-	Over/Under	tolerance	Temperature/Cure
ŀ	Cracks	or correct	11110 10 1	" ⊢	Broken/Damaged	\vdash	ction Incomplete		Part Incorre	_	Weld
ŀ	Crushed/	Crimped		<u> </u>	Burrs	—	ctions Incomplete,	/Unclear	Part Lost/M	<u> </u>	Wrong Stock Pulled
f	Cuffs	cpcu			Contamination	├ ──	tenance	- Cricical	Part Moved		
f	Heat Trea	at		-	Countersink	Misla			Positioned \	Vrong	
}	Inspectio		Tube	-	Cut Too Short	Misre		<u> </u>	Power Loss/		Other
	Ripples in		-		Drill Holes	Offse			_	Ŭ L	
ļ	Torque W		xtrusion	,	Drawing	\vdash	f Calibration				
	Turning S			-	Finish	Out o	f Sequence				<u> </u>
	Wave/Tw			-	Folio	—	de Dimensions				

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	Vork Order ID 87504 uly-19-12 11:09:12 AM			*87504*								Page 2
Item ID: Revision ID: Item Name:	D4020-3	3 50 Basket Short, Base)		Accept	*N900	040	100	*	Setup	Start Stop		S1* S2*
Start Date: Required Date: Reference:	7/10/12 8/03/12		*2* *2*	i	Cust Item II Customer:	D:					14	
Approvals:	Proces QC:	s Plan:	Date:	Tooling: SPC (Y/N):		te:			Run	Start Stop	*N *N	R1* R2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty	-	Reject Number	Insp. Stamp
*140 *140* QC		QC21- Final Inspection -	Work Order Release	0.00			-			3/1	190	#

Memo

Quality Control

71/1/8) MF 12-27

									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	ONFORM	MANCE / UP		QA Closed:	Date:	
Work Order:				<u> </u>	DISPOSITION			AGAINST DEI	PARTMENT	/PROCESS	
Part No.					Scrap Machining Small Fab Prod. Eng. Co Use-as-is Thermoforming Finishing Rec/Store/Packag Work Order Update Large Fab Composite Supplemental Sign & Sig						Engineering Quality Other
Root				Descri	ption of work order update	Initial	Act	tion	Sign &	_	
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator		i									
Material											
Setup	j							•		•	
Other	`										
Process								:	i		
Supplier											
Training]										,
Unapproved											

	-		FAUL	LT CATEGORY		
Landing	Gear	General		_	_	
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped.	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination		Maintenance	Part Moved	
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		
	Torque Waves in Extrusion	Drawing		Out of Calibration		
	Turning Sequence	Finish		Out of Sequence		
	Wave/Twist in Tube	Folio		Outside Dimensions		

Picklist Print

July-19-12 11:09:11 AM

Work Order ID:

87504

Parent Item:

D4020-3

Parent Item Name:

Mesh (350 Basket Short, Base)

Start Date: 7/10/12

Required Date: 8/03/12

Page 1

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP RevA: new issue DD 09.11.26 verified by:EC

verified by:EC

IPP Rev:B as per dwg revA 10.03.15

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	609.7005	19.1516	40.319158	6	(12.	12.01
Expanded Metal Flat SS									0.E 1.E				77

Location	Loc Oty	Loc Code	M123855 -> 20.15
WA035	609.7004637		
117197	102.9036		
120917	50.88673		
121521	0.00013372		
122080	112.72		
122138	23.19		
122315	320		

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-C	10	NFORM	MANCE / UP	DATE		_			
											C	QA Closed:	Da	te:	· · · · · · · · · · · · · · · · · · ·
Work Ord	er.					DISPOSITION				AGAINST DI	EΡ	ARTMENT/	PROCESS		
Part f						Rework Scrap Use-as-is		ſ	Skid-tube Machining Moforming	Crosstube Small Fab Finishing			Water Jet d. Eng. Coor. e/Packaging		Engineering Quality Other
NCR f	No.					Work Order Update			Large Fab	Composite]		Supplier	_	
Root					Descri	ption of work order update	- 1	nitial	Act	tion		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription		Date	Verificatio	n_	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved															
						F/ General	AUL	T CATE	GORY						
Lation	Landing Gear General Bending Bend Centre Not Concentric to O/S BOM/Route Cracks Broken/Damaged Crushed/Crimped Burrs Cuffs Contamination Heat Treat Countersink				4	on Incomplete ions Incomplete/ enance	Unclear		Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V	ct ssing		Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled			
		Inspection	n Strip in	Tube		Cut Too Short		Misread	d]ı	Power Loss/	Surge		Other
		Ripples in	Bend			Drill Holes		Offset			_				

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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SHOP COPY RETURN TO **ENGINEERING UNCONTROLLED COPY** SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 87504 MCJ 12/07/20 15.13 15.61 19.52 R3.0 9 <u>D4020-1 MESH (350 BASKET LONG, BASE)</u> (SEE D4020-1F FOR LENGTH) D4020-3 (350 BASKET SHORT, BASE) (SEE D4020-3F FOR LENGTH) NOTES:
1) MATERIAL-1: MAKE FROM D4020-1F
-3: MAKE FROM D4020-3F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
8) IDENTIFICATION N NEW ISSUE 10.03.04 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 6) IDENTIFICATION: N/A MFG. APPR. SHEET 1 OF 4 6) IDENTIFICATION: NW.
7) WEIGHT: SEE D4020-1F & D4020-3F
8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) PRE-FORMING OF MESH PER SHOP OPTION, THIS VIEW MAY BE USED FOR REF ONLY APPROVED TITLE SCALE 350 BASKET MESH (BASE) DE APPR. NTS DATE 10.03.04

											DQA:	Date:	_
NCR: Y	Yes	/ No				WORK ORDER NON-	CON	FOR	MANCE / UP	DATE	04.01	D-4	
	-										QA Closed:	Date:	
Work Orde	or.					DISPOSITION				AGAINST DE	PARTMENT	PROCESS	
Work Orde	-''-					Rework	7	٠	Skid-tube	Crosstube]	Water Jet	Engineering
Part N	۷o					Scrap]		Machining	Small Fab	-1	d. Eng. Coor.	Quality
						Use-as-is	-	Thern	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	۷o. ₋					Work Order Update	J		Large Fab	Composite	j	Supplier	
Root					Descri	ption of work order update	lr	nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data		•											
Equip/Tooling													
Operator	Ш												
Material	Щ												
Setup	Ш								[
Other	Ш												
Process	Ш												
Supplier	Н												
Training	\vdash												
Unapproved								T CATE	CORY		1	L	
land:		`~~				r General	AUL	CAIL	JONI				
Landi	$\overline{}$	Bending				General		Grain			Ovalized		Pressure/Forced

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

Over/Under tolerance

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Temperature/Cure

Wrong Stock Pulled

Weld

Other

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

Broken/Damaged

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

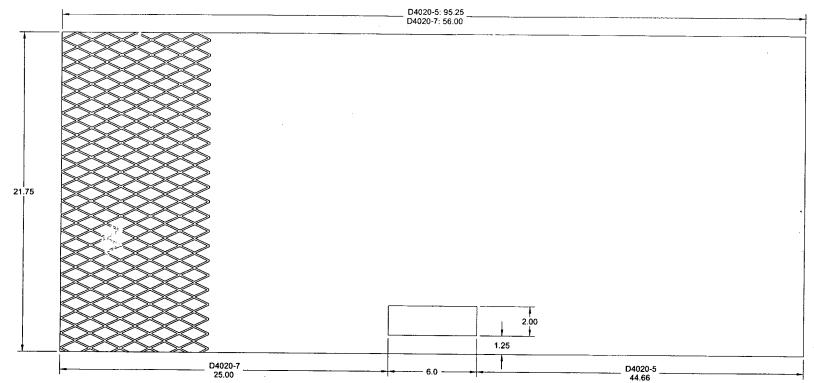
Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S



(B) D4020-5 MESH (350 BASKET LONG, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY)

9 D4020-7 MESH (350 BASKET SHORT, LID) (LOCAL SECTION MESH SHOWN FOR CLARITY)

NOTES:
1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A
7) WEIGHT -5: 0.80 lbs APPROX

DESIGN AJS **DART AEROSPACE LTD** DRAWN JPH HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. A D4020 MFG. APPR. SHEET 2 OF 4 APPROVED TITLE SCALE 350 BASKET MESH (BASE) DE APPR. NTS DATE 10.03.04

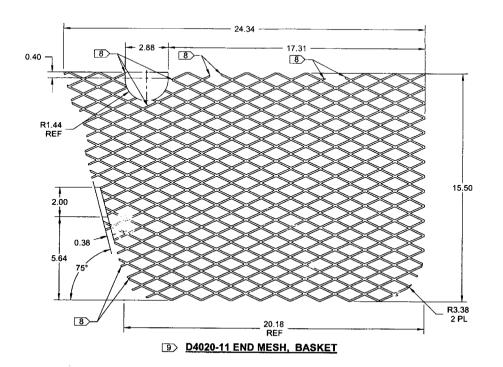
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THIS DOGMENT IS PRIVATE AND COMPIDENTIAL AND IS SUPPLIED ON THE EXPRESS COMMINIOT TO BUILDED FOR MAY PROPOSE OR COMPIDE ON COMMINIOTING TO ANY OTHER PRESSOR OF COMPINIOTING TO ANY OTHER PRESSOR OF COMPINIOTING TO ANY OTHER PRESSOR OF COMPINIOTING TO THE PROPOSED ON THE PROPOSED

DQA: Date: **WORK ORDER NON-CONFORMANCE / UPDATE** NCR: Yes / No QA Closed: Date: **AGAINST DEPARTMENT/PROCESS** DISPOSITION Work Order: Engineering Skid-tube Crosstube Water Jet Rework Small Fab Prod. Eng. Coor. Quality Scrap Machining Part No. Rec/Store/Packaging Other Use-as-is Thermoforming Finishing Supplier Work Order Update Large Fab Composite NCR No. Action Description of work order update Initial Sign & Root Verification QC Inspector Date Step Qty or Non-conformance Chief Eng Description Date Cause Doc/Data Equip/Tooling Operator Material

			FAUI	LT CATEGORY		
Landing	Gear	General			 _	
	Bending	Bend		Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route		Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged		Inspection Incomplete	Part Incorrect	Weld
Γ	Crushed/Crimped	Burrs		Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
Γ	Cuffs	Contamination		Maintenance	Part Moved	
	Heat Treat	Countersink		Mislabeled	Positioned Wrong	 ·
4	Inspection Strip in Tube	Cut Too Short		Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes		Offset		
,	Torque Waves in Extrusion	Drawing		Out of Calibration		 ,
	Turning Sequence	Finish	. [Out of Sequence		
· [Wave/Twist in Tube	Folio		Outside Dimensions		

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Setup Other Process Supplier Training Unapproved



NOTES: 1) MATERIAL: AISI 304/316 EXPANDED STAINLESS STEEL MESH 3/4-16F REF DART SPEC. M304EX0.75-16F

2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: N/A
6) IDENTIFICATION: N/A

8) LOCAL TRIM MAY BE NECESSARY TO CLEAR FASTENERS/STRUCTURE SEE NEXT ASSY FOR DETAILS
9) TOLERANCE ON XX.XX DIMENSIONS ± 0.06.

DESIGN AJS DART AEROSPACE LTD DRAWN JPH HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4020 MFG. APPR. SHEET 3 OF 4 TITLE APPROVED 350 BASKET MESH (BASE) DE APPR. DATE 10.03.04 COPYRIGHT @ 2010 BY DART AEROSPACE LTD

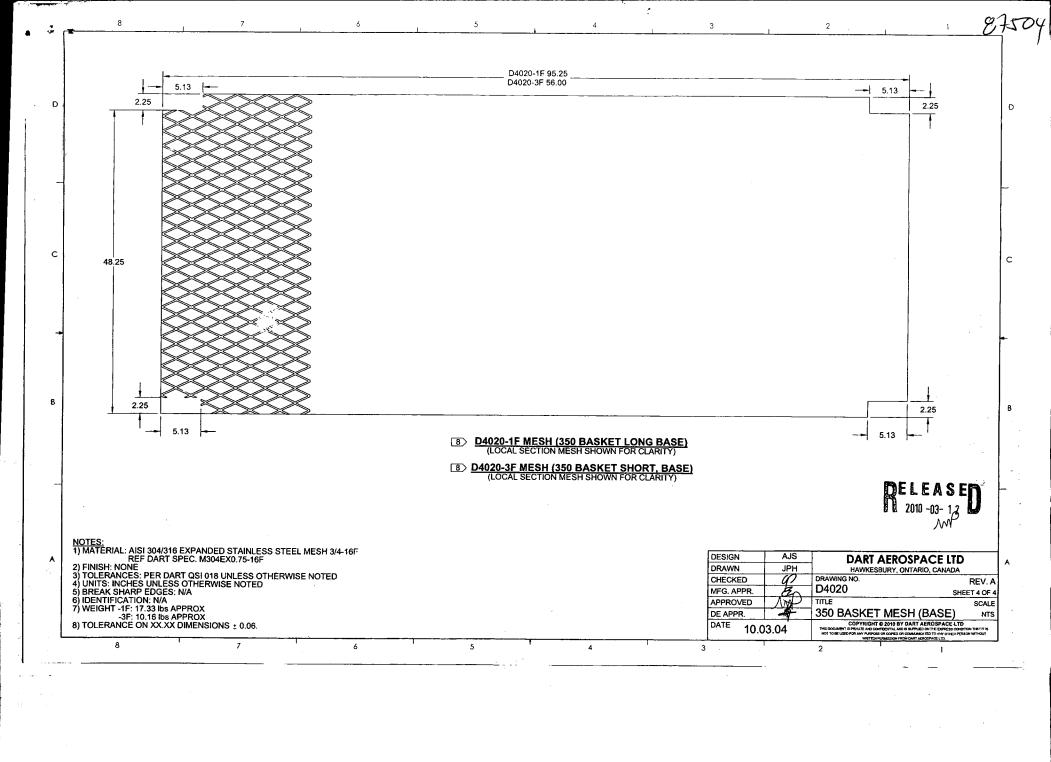
NCR:	Yes	/	No

DQA:

Date:

NCR: Ye	es / No				WORK ORDER NON-O	CONF	ORN	MANCE / UP		QA Closed:	Date:		
Work Ordei	r·		*		DISPOSITION		AGAINST DEPARTMENT/PROCESS						
		· · · · · · · · · · · · · · · · · · ·		<u>.</u>	Rework]	Skid-tube Crosstube Machining Small Fab			Pro	Engineering Quality		
Part N	o				Scrap	Machining			Finishing	1	Other		
NCR N	0				Work Order Update	Use-as-is Thermoforming Vork Order Update Large Fab			Composite	Rec/stor	e/Packaging Supplier		
Root	Description of work order update				Ini	tial	Ac	tion	Sign &				
Cause	Date	Step	Qty	1	or Non-conformance	Chie	hief Eng Description		ription	Date	Verification	QC Inspector	
Doc/Data													
Equip/Tooling						1							
Operator									•			ļ	
Material						!							
Setup													
Other													
Process	·												
Supplier												1	
Training		-		•									
Unapproved		1											
					F	AULT	CATE	ORY					
Landin	g Gear				General					_	·		
	Bending			· · · · · · · · · · · · · · · · · · ·	Bend	G	Grain			Ovalized		Pressure/Forced	
	Centre N	ot Conce	ntric to (o/s	BOM/Route	Hardw		are		Over/Under tolerance		Temperature/Cure	
	Cracks				Broken/Damaged	In	Inspection Incomplete			Part Incorrect		Weld	
ľ	Crushed/	Crimped			Burrs	In	Instructions Incomplete/Unclear		Part Lost/Missing Wrong Stock F		Wrong Stock Pulled		
	Cuffs				Contamination			Maintenance				_	
	Heat Trea	at			Countersink	Mi		Mislabeled		Positioned Wrong			
	Inspectio	n Strip in	Tube		Cut Too Short	\square	1isread	ead		Power Loss/	Surge	Other	
ľ	Ripples in				Drill Holes	По	ffset			=	_		
ľ	Torque V		Extrusio	,	Drawing	По	ut of C	Calibration				,	
. [Turning Sequence Finish				Out of Sequence							
<u> </u>	M/ave/Tu	-		<u> </u>	T _{Eolio}	$\boldsymbol{\vdash}$		Dimensions					

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NCR:	Yes	/	No
IVCh.	162	,	110

DQA:____

Date:

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE														
								·		QA Closed	Date:			
Work Orde	r.				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
			···	······································	Rework	7		Skid-tube	Crosstube	Water Jet Engineering				
Part N	lo.				Scrap	1	Machining Small Fab			Pro	d. Eng. Coor.	Quality		
					Use-as-is	7 I	Thermoforming Finishing			Rec/Stor	e/Packaging	Other		
NCR N	lo				Work Order Update	Large Fab Composite			Supplier					
Root Descri					iption of work order update	In	Initial Action			Sign &				
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Desc	Description		Verification	QC Inspector		
Doc/Data									•					
Equip/Tooling									Ç.					
Operator														
Material														
Setup														
Other						-								
Process														
Supplier														
Training														
Unapproved				<u> </u>	·									
						FAULT	CATE	GORY						
Landi	ng Gear			_	General					ר	r	, ר		
	Bending				Bend		Grain			Ovalized		Pressure/Forced		
	Centre I	Not Conce	ntric to	o/s	BOM/Route		Hardwa		<u> </u>	Over/Under tolerance Temperature/0				
	Cracks			<u> </u>	Broken/Damaged	_	Inspection incomplete			Part Incorrect Weld				
	-	l/Crimped	ē	L	Burrs		Instructions Incomplete/Unclear			Part Lost/Missing Wrong Stock Pulled				
	Cuffs			_	Contamination		Maintenance			Part Moved				
į	Heat Tre			lacksquare	Countersink		Mislabeled			Positioned Wrong				
		on Strip ir	Tube	<u> </u>	Cut Too Short	-	Misread			Power Loss/	Surge	Other		
	Ripples				Drill Holes		Offset							
		Waves in		n	Drawing			Calibration						
		Sequence		_	Finish	\vdash		Sequence		·				
	Wave/T	wist in Tu	be		Folio		Outside	Dimensions						

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